

Date: Monday, 02/06/2008 4:32:17 PM
 User: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	MIRROR BRACKET
Job Number :	39636A		
Estimate Number :	10142		
P.O. Number :		Part Number :	D2161204
This Issue :	02/06/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Number :	D2161 REV B2
First Issue :	/ /	Project Number :	N/A
Previous Run :	36919	Drawing Revision :	B2
	Type :	Material :	
	SMALL /MED FAB	Due Date :	10/06/2008
Written By :		Qty:	5
Checked & Approved By :	JLD 08.6.02	Um:	Each
Comment :	Est Rev:A New Issue 05-11-01 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	39636A01	MIRROR BRACKET
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Comment: Sub-Component MIRROR BRACKET
 D2013-5 B B 39636A01 ✓

Plc 09.02.11

2.0	39636A02	MIRROR BRACKET
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Comment: Sub-Component MIRROR BRACKET
 D2013-6 B B39636A02 ✓

Plc 09.02.11

3.0	39636A03	ARM
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Comment: Sub-Component ARM
 D2037-101 B 41854 → 1 ✓ B41316A03 → 4 ✓

Plc 09.02.11

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Assemble on Jig DT8065 as per Dwg D2161

2-Weld as per Dwg D2161 Identify as D2161-204

Plc 09.02.11

5.0	DO NOT USE	WELD INSPECTION
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Comment: WELD INSPECTION

5.1 QLS *for 12* (8)

(X5)

(P70)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
09.02.11	5.0	After Sequence 4.0 there should be a QA check. Please change. Perm. Change	HJ	09.02.20				

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Job Number: 39636A

Part Number: D2161204

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

POWDER COATING

POWDER COATING



M 10 5642



(5X)

Comment: POWDER COATING

Powder Coat Black Sandtex (Ref: 4.3.5.7) as per QSI 005 4.3

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10 = 10
320 OF
10 = 40

M-L 09/02/14

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



PPD 45877



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

09/02/14 (S)

8.0

QC21

FINAL INSPECTION/W/O RELEASE



09/02/2014

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



mf
09-02-18

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

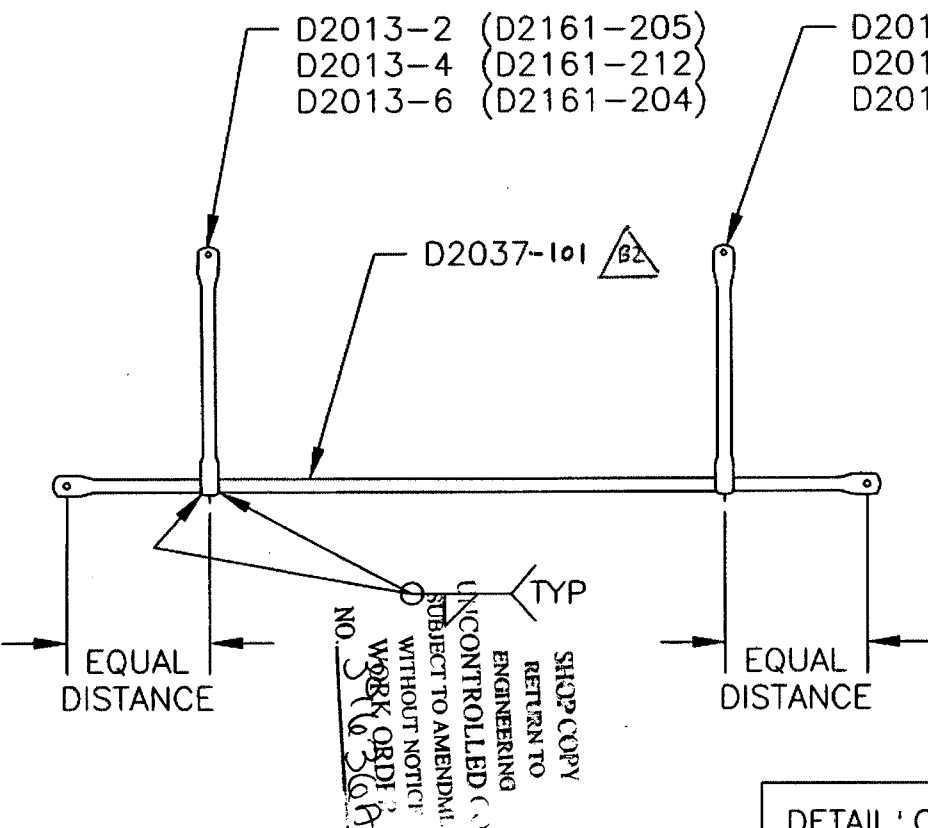


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
JB	RT	DRAWING NO.	REV. B
CHECKED JE	APPROVED RT	D2161	SHEET 1 OF 1
DATE 99.06.07	TITLE MIRROR BRACKET	SCALE NTS	
A	93.04.29	NEW ISSUE	
B	99.06.07	REDRAWN FOR CLARITY ADDED -204/-205/-212 DESIGNATIONS	
B1	02.03.25	CHANGE FINISH	
B2	02.06.14	D2037-101 W	

PLACE SHORTER ARM
ON SIDE OF JIG DT8065
LABELED FWD (TYP)

D2037-101 $\triangle B2$
WELD FLAT
END PARALLEL TO
THE SHORT ARM

DETAIL OF D2161-204
DETAIL OF D2161-205
DETAIL OF D2161-212



NOTE: WELD ASSEMBLY
USING JIG DT8065

FINISH: ~~POWDER COAT ASSEMBLY BLACK~~
~~CRINKLE (4.3.5.3) PER DART QSI 005 4.3~~
POWDER COAT BLACK SANDTEX (4.3.5.7) PER
DART QSI 005 4.3 $\triangle B1$

RELEASED
KE 99.06.10